

Work Order ID 63122

Thursday, October 21, 2010 1:29:10 PM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 10/21/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-10-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

120 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

10-10-25

⑧

130 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

SL 10/11/17

⑧

140 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/11/17

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item ID:	D2432	Accept		Setup	Start	
Revision ID:						
Item Name:	206 (24") Bearpaw				Stop	
Start Date:	10/21/2010	Start Qty: 8.00		Cust Item ID:		
Required Date:	10/28/2010	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	0		
151  Packaging Packaging	Identify as per dwg & Stock Location: <i>PDP</i> Memo <i>6364</i>	0.00 0.00							<i>CC 10/11/18 (8)</i>
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/11/18</i> <i>MF</i> <i>10-11-18</i>

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Picklist Print

Thursday, October 21, 2010 1:29:14 PM

Page 1

Work Order ID: 63122



Parent Item: D2432



Parent Item Name: 206 (24") Bearpaw

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

24.3060

3.7

29.6



B 10-10-25

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT

24.306

114624

8.8

115325

15.506

115955

115955

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DART AEROSPACE LTD		Work Order: 43122
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Van SL-3	
B	5.500	+/-0.030	5.503	✓			
C	0.200	+/-0.030	0.195	✓			
D	0.25 x 45°	+/-0.030	0.250 x 45°	✓			
E	R0.250	+/-0.030	0.250	✓			
F	0.250	+/-0.010	0.250	✓			
G	0.625	+/-0.030	0.625	✓			
H	0.375	+/-0.010	0.375	✓			
I	0.950	+0.030/0.010	0.950	✓			
J	19.000	+/-0.030	19.00	✓			
K	3.14	+/-0.030	3.14	✓			
L	3.28	+/-0.030	3.28	✓			
M	Ø0.260	+0.005/-0.000	0.260	✓			
N	Ø0.93	+/-0.030	0.925	✓			
O	0.30	+0.030/-0.000	0.315	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	0.380	✓			

Measured by: [Signature]
Date: 10/11/17

Audited by: [Signature]
Date: 10/11/18

Prototype Approval: N/A
Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF [Signature]

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F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

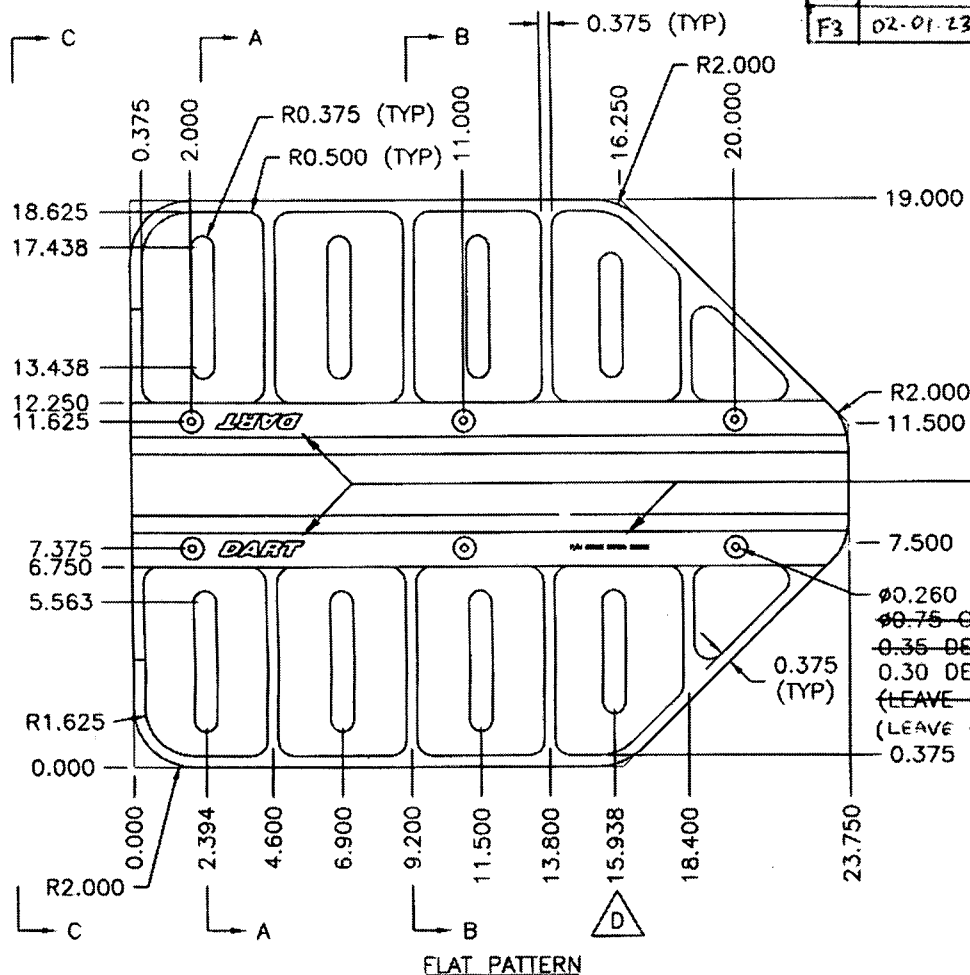
SHOP COPY
RETURN TO

ENCLOSING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
WORK ORDER
NO. 122
10-10-21



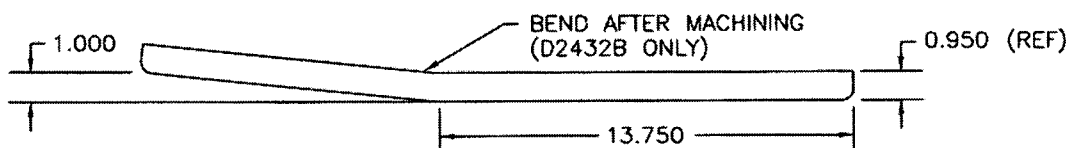
RELEASED
93.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ & Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N
		SCALE 1:6

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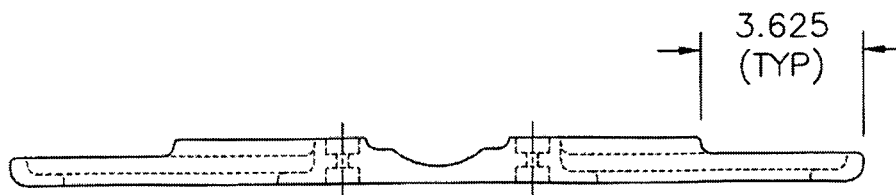
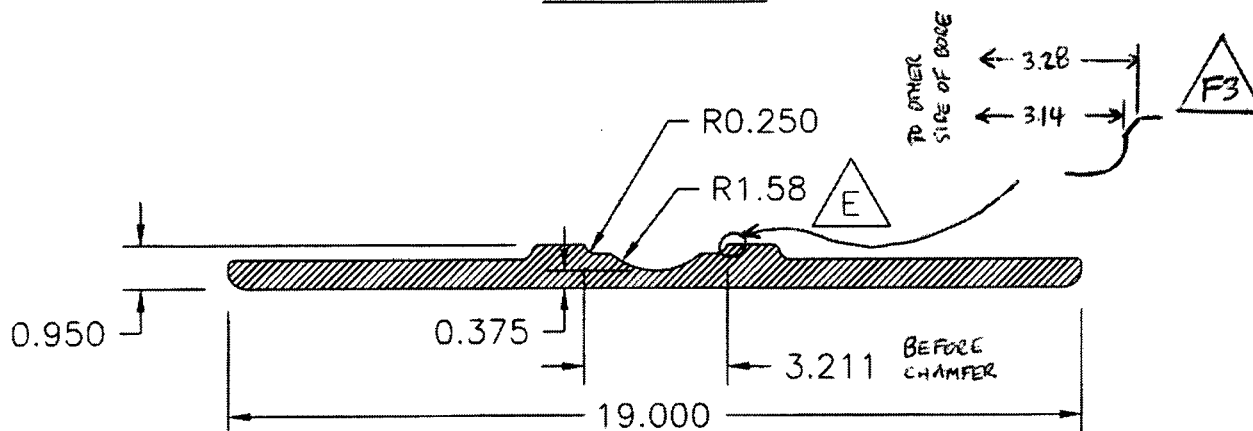
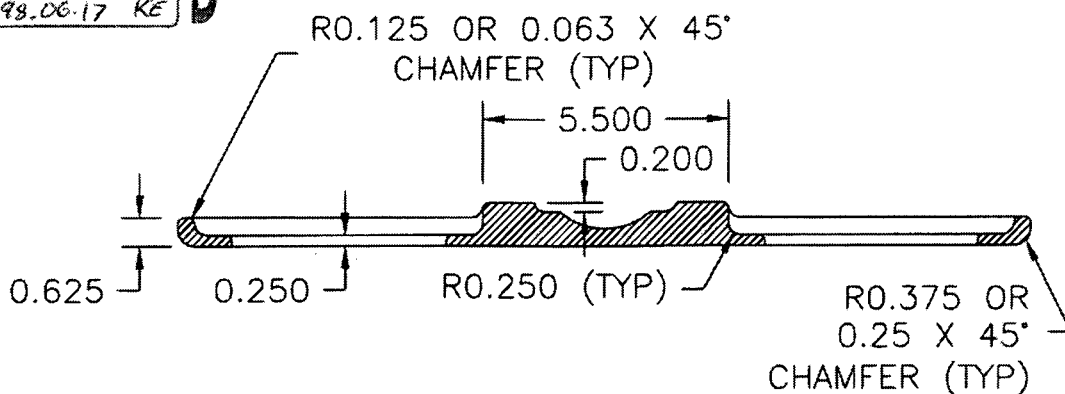
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

w/o 43122



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